



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3078-041
Job Sheet 182700



Part No: D3078-041

Job Qty: 5 ea

Part Name: Step Assembly, Hi Short LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/30/18

Job Tracking No:

Due Date: 9/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 15.11.12 NEW ISSUE DD VERF:JLM IPP REV:B 16.03.15 DWG REV:B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	9/14/18	9/14/18	0.00	0.00	Start Up Large Fab-4		SLH
110	Large Fab	5 pcs	9/14/18	9/14/18	0.00	5.05	Large Fab 8		SLH
120	QC	5 pcs	9/14/18	9/14/18	0.00	0.00	QC6		SLH
130	Large Fab	5 pcs	9/14/18	9/14/18	0.00	5.05	Large Fab 2		CPC
140	QC	5 pcs	9/14/18	9/14/18	0.00	0.00	QC9		SLH
150	QC	5 pcs	9/14/18	9/14/18	0.00	0.00	QC5		SLH
160	HandFinish	5 pcs	9/14/18	9/14/18	0.00	0.59	HandFinish1		D.B. 18/09/18
170	QC	5 pcs	9/14/18	9/14/18	0.00	0.00	QC7-2		CPC
200	Large Fab	5 pcs	9/14/18	9/14/18	0.00	5.05	Large Fab 2		DAS CPC
210	QC	5 pcs	9/14/18	9/14/18	0.00	0.00	QC10		38 DAS
220	QC	5 pcs	9/14/18	9/14/18	0.00	0.00	QC5		9-89 38
240	HandFinish	5 pcs	9/14/18	9/14/18	0.00	0.59	HandFinish6		D.B. 18/09/18
250	Powdercoat	5 pcs	9/14/18	9/14/18	0.00	1.14	Powdercoat1		BR 18-9-18
260	HandFinish	5 pcs	9/14/18	9/14/18	0.00	0.59	HandFinish3		18-9-18
270	QC	5 pcs	9/14/18	9/14/18	0.00	0.00	QC3		SEP 19 2018 68
290	Packaging	5 pcs	9/14/18	9/14/18	0.00	0.00	Packaging3-1		SEP 19 2018 9-89
300	QC21-SA	5 Ea	9/14/18	9/14/18	0.00	0.00	QC21		SEP 20 2018

Part Op 110 - 1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg D3078 using Jig DT8680
Descriptions: for rivets. 3-Deburr

130 - 1-Bevel end for welding FWD ONLY 2-Weld Support, weld Fwd End Plate as per QSI 004 & Dwg D3072 A/R Aluminum Rod 138745 3-Grind End Plate flush

200 - 1- Rivet Leg Assembly as per Dwg D3078. 2-Bevel Aft end for welding 3-Inspect for foreign object as per QSI 024 4-Weld Aft End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod 5-Grind End Plate flush

250 - START TIME: 1:55 OVEN TEMPERATURE: 300 FINISH TIME: 2:25

1183592

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2.5000 Ea (.5 ea)	90-Start up Operation	5104007
D3067-1	End Plate	10 Ea (2 ea)	130-Large Fab	5090880
D3219-3	Plate	10 Ea (2 ea)	130-Large Fab	① B161508 / 5091006 ②
D3065-041	Step Leg Assembly	5 Ea (1 ea)	200-Large Fab	5109745 ③ 5102250 ④
D3066-1	Spacer	10 Ea (2 ea)	200-Large Fab	5077435 ⑤ 5105216 ⑥

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

MS20600-AD4W4

Rivet

80 Ea (16 ea)

200-Large Fab

S057529

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	3	199	0
130-Large Fab	D3067-1	10	183	0
	D3219-3	10	29	0
200-Large Fab	D3065-041	5	18	0
	D3066-1	10	110	0
	MS20600-AD4W4	80	1,250	0

Part Specifications

Specifications could not be found.

Plex 8/30/18 10:35 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Reweave ☐ Scrapped ☐ Use-as-is ☐ Suspected Unapproved ☐		 Container No: S107967 Part: D3078-041 Job No: 182700 Serial No/Batch: S107967 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's DATE: 09/04/18 UART Aerospace Ltd. 1270 Aberdeen Street Hamilton, ON K6A 1K7 CANADA TEL: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com	
Date :		Step #:			
Description Work Order Deviation					

Root Cause			FAULT CATEGORY		
☐ Environment	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Design	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
☐ Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Equip/Tooling	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
☐ Handling/Pre	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Material	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved
☐ Internal Transport	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing
☐ Tribal Knowledge	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish
☐ LOA	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
☐ Substation	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence
☐ Past Expiry Date	☐ Manufacturing Process	OTHER : _____			
☐ Misidentified	☐ Past Due				